Work Ord March-27-13		8862	,	*988	862*						Page 1
Item ID: Revision ID: Item Name:	D4081-1 Bushing			Accept	*N900	<b>04</b> 0	100	<b>)*</b> s	Setup Sta	1/1	S1* S2*
Start Date: Required Date Reference:	3/27/13 e: 4/10/13	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*	,	Cust Item I Customer:	D:				I	(1)
Approvals:	Process P QC:	lan:		Tooling: SPC (Y/N):		ate:		F	tun Star Sto	<b>VI</b> "	R1* R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr		· · · · · · · · · · · · · · · · · · ·							
D4081	A										
100 *100* Hardinge		Memo		0.00				24	Ø		DAS 13 89
Hardinge CNC Lat	the Small			13-5-	8	,					
		DEBURR									
110		QC2- Inspect parts off ma	chine FAI/FAIB	, 0.00							DAG
*110*								2 (	h		13

Memo

Quality Control

NCR: Y	/es	/ No				WORK ORDER NON-C	O	<b>NFORM</b>	MANCE / UP	DATE			
		•							<u> </u>		QA Closed:	Date:	
Work Orde	òr.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG		<del></del>				Rework	1 [		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	ا No.					Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update	1	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	$\Box$												
Operator	Ц		1										
Material	Ц		•										
Setup	$\square$					,	Ì						
Other	_				1								
Process	Щ				}		ļ					:	
Supplier				1									
Training			i										
Unapproved				l						<del> </del>	<u> </u>		
							AUL	T CATE	GORY			- <del></del>	
Landi					<del></del> -	General	_	1			7		T
	-	Bending			<u> </u>	Bend	$\vdash$	Grain		<u> </u>	Ovalized	ļ	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	Hardwa			Over/Under	<del></del>	Temperature/Cure
	Щ	Cracks				Broken/Damaged	-	•	on Incomplete		Part Incorred	<b>├</b>	Weld
		Crushed/	Crimped			Burrs	Ш	instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	nance	<u></u>	Part Moved		
		Heat Trea	at		<u>L</u>	Countersink	$\Box$	Mislabe	led	<u></u>	Positioned V		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1	<u></u>	Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-27-13 9:21:51 AM

Item ID:

D4081-1

Accept

\*N900040100\*

Setup Start

Item Name:

Required Date: 4/10/13

**Revision ID: Start Date:** 

Bushing 3/27/13

Start Qty: 24.00 Req'd Qty: 24.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: Date: Tooling:

Date: \_\_\_\_

Run

QC: \_\_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N):

Date:

\*NID2\*

								17	<b>N</b> /
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							-
*120* QC Quality Control	Memo	0.00 F.A	13/05/0	ৰ্ষ		24	ø		

130

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\* HandFinish

Hand Finishing

Memo

0.00

24 1613.58

140

QC3- Inspect Part Finish

0.00

\*140\*

Quality Control

Memo

0.00

<del>JUX</del>

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UF	PDATE			
											QA Closed	: Date	:
Work Ord	oř.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ct	nief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	L			1		·							
Operator	L					•							
Material	L					,							
Setup	L	]											
Other	L				1	1							
Process	L	j				t.							
Supplier		1										ł	
Training						r							
Unapproved			.1								<u> </u>	<u> </u>	
						<del></del>	AUI	LT CATE	GORY				
Land	ing (	Gear				General	_	-			٦	_	<del>-</del> 1
		Bending				Bend	$\perp$	Grain			Ovalized	<u> </u>	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire	· L	Over/Under	tolerance	Temperature/Cure
}	L	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
	$\perp$	Crushed/	'Crimped		_	Burrs	L	Instruct	tions Incomplete	/Unclear	Part Lost/M	· ·	Wrong Stock Pulled
	L	Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink	L	Mislabe	eled		Positioned \	Nrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	<del>d</del>		Power Loss,	/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

**Drill Holes** 

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-27-13 9:21:51 AM

Item ID: D4081-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Bushing **Start Date:** 3/27/13 **Start Qty: 24.00 Cust Item ID:** Required Date: 4/10/13 Req'd Qty: 24.00 **Customer:** Reference: Run Process Plan: Date:\_\_\_\_\_ Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Accept Work Center ID Description **Run Hours** Qty Code Qty Number Stamp Identify as per dwg & Stock Location: 150 \*150\* Packaging 0.00 Memo Packaging 160 QC21- Final Inspection - Work Order Release 0.00 \*160\* MLJ 13-0509 QC 0.00 Memo Quality Control

						•					DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UPDATE		QA Closed:	Date	•
						<u> </u>			4.04141	CT 0.5	-	· · · · · · · · · · · · · · · · · · ·	e
Work Ord	er:					DISPOSITION			AGAIN	SIDE	PARTMENT	/PROCESS	
Part I NCR I						Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstul Machining Small Fa noforming Finishin Large Fab Composi	ab ng	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			<u> </u>		Descr	iption of work order update	Τ	Initial	Action		Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	CI	hief Eng	Description		Date	Verification	QC Inspector
Doc/Data							1	•					
Equip/Tooling						•							
Operator						ı	-						
Material						· ·							
Setup													
Other				}									1
Process						1							
Supplier						i							
Training						1							
Unapproved					<u> </u>	;							
							FAU	LT CATE	GORY				
Landi	ing (	1			_	General	_	<b>-</b> 1			7	. ~	<b>-</b>
	$\vdash$	Bending	•			Bend	L	Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	$\perp$	Hardwa		$\perp$	Over/Under	<b>—</b>	Temperature/Cure
	_	Cracks			<u>_</u>	Broken/Damaged	$\perp$	<b>⊣</b> '	ion Incomplete	<u> </u>	Part Incorre	<b>-</b>	Weld
	<u> </u>	Crushed/	Crimped		· <u>L</u>	Burrs	Ŀ	-	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
	$oxed{L}$	Cuffs			<u> </u>	Contamination	L	Mainte	enance	<u> </u>	Part Moved		
	1	Hoat Tro	n+		1	Countersink		Miclahe	alad	1	Positioned \	Mrong .	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 98862

Parent Item:

D4081-1

Parent Item Name: Bushing

\*98862\*

\*D4081-1\*

**Start Date: 3/27/13** 

Required Date: 4/10/13

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP REV:A NEW IISUE 10-05-04 JLM VERIFIED BY:EC

REV:B change material size 11/05/18 JFS verf: DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	384.8490	0.104	2.627368		۲ ،	2AC
*M6061T6	, , , , , , , , , ,	W 058*	•						**	/3-	5-8		DAS 13 289/

6061-T6 RD Tube .375 x.058W

<b>Location</b>	Loc Qty	Loc Code	
MAT014	384.849		
116920	1.156		
119087	0.11		
123303	8		11
123449	249.8		2-684
123844	111.517		
124069	14.266		

Page 1

												DQA:	D:	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UI	PDATE					
												QA Closed:	D	ate:	
Work Ord	or.					DISPOSITION				AGAINST DI	EP	PARTMENT	PROCESS		
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jei d. Eng. Coor e/Packaging Supplie		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Α	ction	ı	Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	nief Eng	Des	cription	╛	Date	Verification	วท	QC Inspector
Doc/Data	L														
Equip/Tooling					ļ	•									•
Operator						•									
Material			ŀ			•									
Setup			1												
Other			9				1				١				
Process									Ì		١				
Supplier			Ì								1				
Training		]													
Unapproved															
						·	AUI	LT CATE	GORY	·					
Land	ing (	Gear				General		_		_	_			_	•
		Bending			<u> </u>	Bend	L	Grain				Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	O/S	BOM/Route	L	Hardwa	ire		╝	Over/Under	tolerance		Temperature/Cure
	L	Cracks				Broken/Damaged	_	Inspecti	ion Incomplete		╛	Part Incorred	t		Weld
		Crushed/	Crimped			Burrs	L	Instruct	tions Incomplete	/Unclear	_	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	enance			Part Moved			
		Heat Tre	at			Countersink		Mislabe	eled		╛	Positioned V	Vrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d		1	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	98862
Description: Bushing	Part Number:	D4081-1
Inspection Dwg: D4081 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments				
1.22	+0.000/-0.030	1213			51-9	(/2)	14				
Ø0.31	+/-0.030	.311				<u> </u>					
Ø0.257	+0.006/-0.001	0.257	'/								
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	10/10		l				· · · · · · · · · · · · · · · · · · ·				
sured by:	13	Audited by:	FK.		Preliminary A	pproval:					
Date: / 3	8-2-2	Date:	13/05	108		Date:					
			12/02	کے ا							

Measured by: 13	Audited by:	FK-	Preliminary Approval:	
Date: 13-89 8	Date:	13/05/08	Date:	

Rev	Date	Change	Rev	ised by	Approved
Α	10.10.07	New Issue	KJ	*X	- 1 / W
			·	<del>'''                                  </del>	

